

Fig. 1

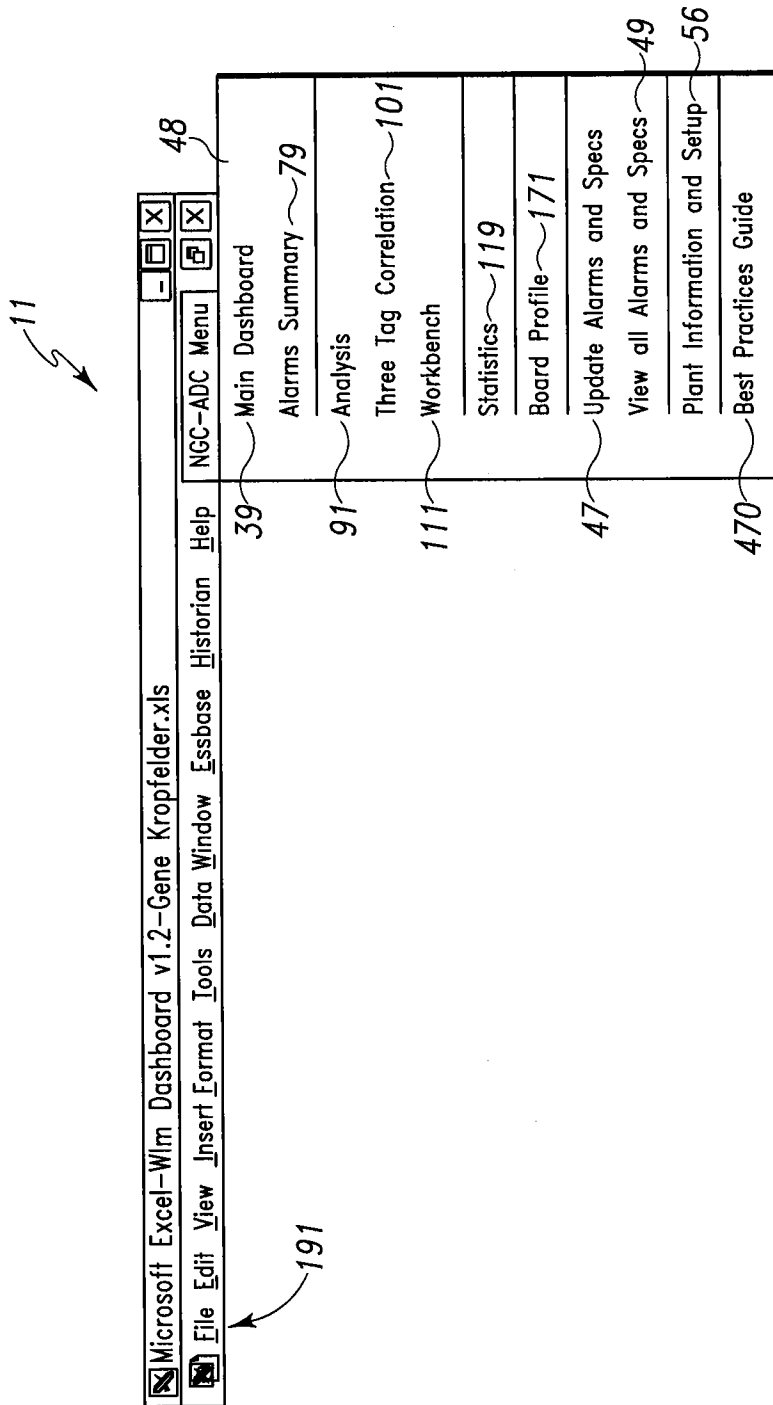


Fig. 2A

Main Dashboard

REQUESTED DAY  
 September 29, 2002

ALARMS

Shift 1 <sup>st</sup>	Shift 2 <sup>nd</sup>	Shift 3 <sup>rd</sup>
8		
9		
5	53	
5		
3		
SETUP TARGET		

PREVIOUS DAY  
 September 28, 2002

ALARMS

Shift 1 <sup>st</sup>	Shift 2 <sup>nd</sup>	Shift 3 <sup>rd</sup>
6		15
5		15
10		13
9		15
10		18
7		21

55 42

54

57

44

45

122

34

41

Fig. 2B

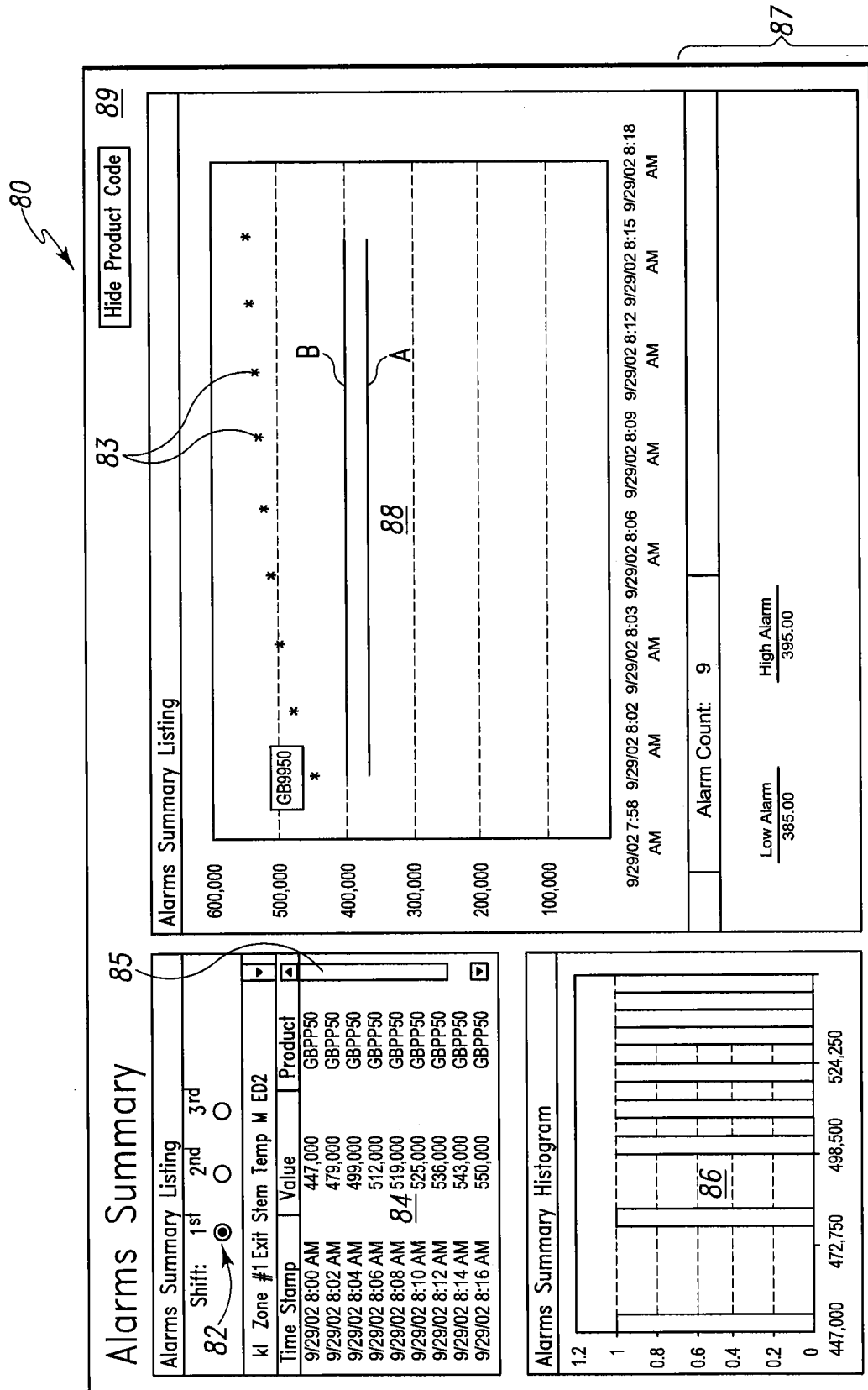


Fig. 3

46

435

## Update Alarms and Specifications

UPDATE  54 ☐ Mill Data ☐ West End Feeds ☐ West End Tests

CANCEL  ☐ Board Tests ☐ Kiln Temp/Most ☐ Free Tags

436 Select Measure/Tag  
 ml - calcine #6 Cutlet Temp Actual 50 57

PLC Value	All	1	2	3	4	5	6	7	8	9	10	11	12	13
Product Description	All	1/2" Reg TE	1/2" HS TE	1/2" SS TE (Sta Smooth)	1/2" SS TE (Sta Smooth)	1/2" KK TE	1/2" db (Durahas e)	1/2" PSE TE	1/2" SC SS (Sta Smooth)	1/2" PSE KK	5/8" FS TE	5/8" FS KK	5/8" FS SS	
Product Code	All	GB4080	GB0019	GB6270	GB0116	GB2280	GB5926	GB6793	GB6601	GB6058	GB9950	GB1280	GB1310	
High Alarm	370	370	370	370	370	370	370	370	370	370	370	370	370	
Low Alarm	330	330	330	330	330	330	330	330	330	330	330	330	330	
Upper Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	0	
Lower Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	0	

44

52

Fig. 4A

Figure 85 is a schematic diagram of a multi-story building, likely a school or office building, showing a grid of rooms. A specific room is highlighted with a dashed line and labeled '85'. The building has multiple floors, and the rooms are arranged in a regular grid pattern. The highlighted room is located in the upper right portion of the grid.

Fig. 4B

60

Product Information				Shift Information	
PLC Value	Product Code	Description	Width (inches)	1st SHIFT	Ends At
0	NONE	NO PRODUCT RUNNING	NONE	8:00 AM	4:00 AM
1	GB4080	1/2" REG/TE	48	4:00 PM	12:00 AM
2	GB0019	1/2" HS TE	48	12:00 AM	8:00 AM
3	GB6270	1/2" SS TE (Sta-Smooth)	48		
4	GB0016	1/2" SS HS (Sta-Smooth)	48		
5	GB2280	1/2" KK TE	48		
6	GB5926	1/2" DB (Durabase)	48		
7	GB6793	1/2" FSC TE	48		
8	GB6601	1/2" SS HS (Sta-Smooth)	48		
9	GB6058	1/2" FSC KK	48		
10	GB9950	5/8" FS TE	48		
11	GB1280	5/8" FS TE	48		
12	GB1310	5/8" FS SS	48		
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					

72

Dual Line Plant	Yes
Line Number	2

74

76

Line Length (Mixer to Knife) -Feet	595
Wet Transfer Length -Feet	30
Kiln Length -Feet	413
Number of Decks in Kiln	8
Kiln Zone 1 Length -Feet	121
Kiln Zone 2 Length -Feet	67
Kiln Zone 3 Length -Feet	205
Kiln Zone 4 Length -Feet	

76

Fig. 5

60

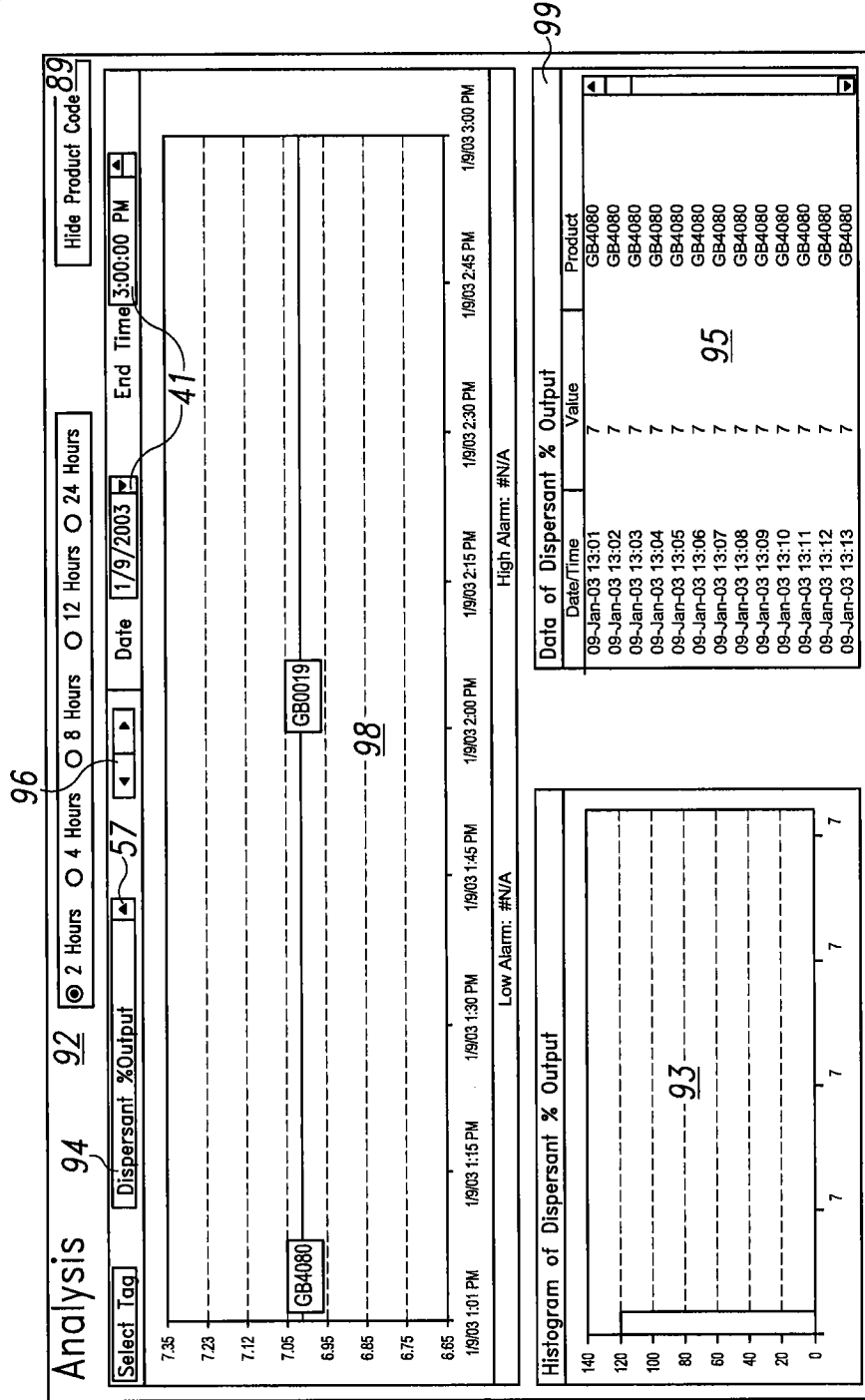
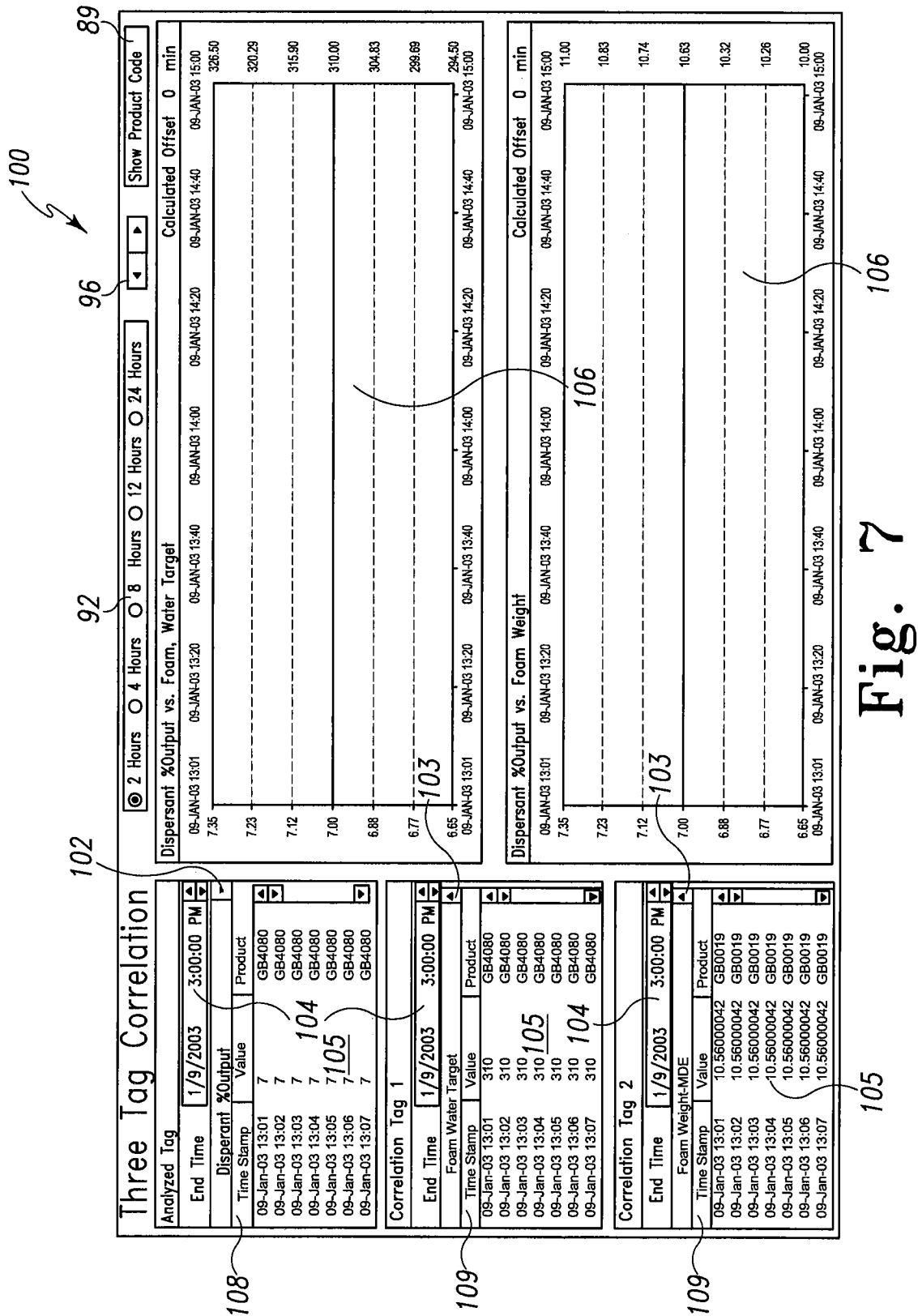


Fig. 6





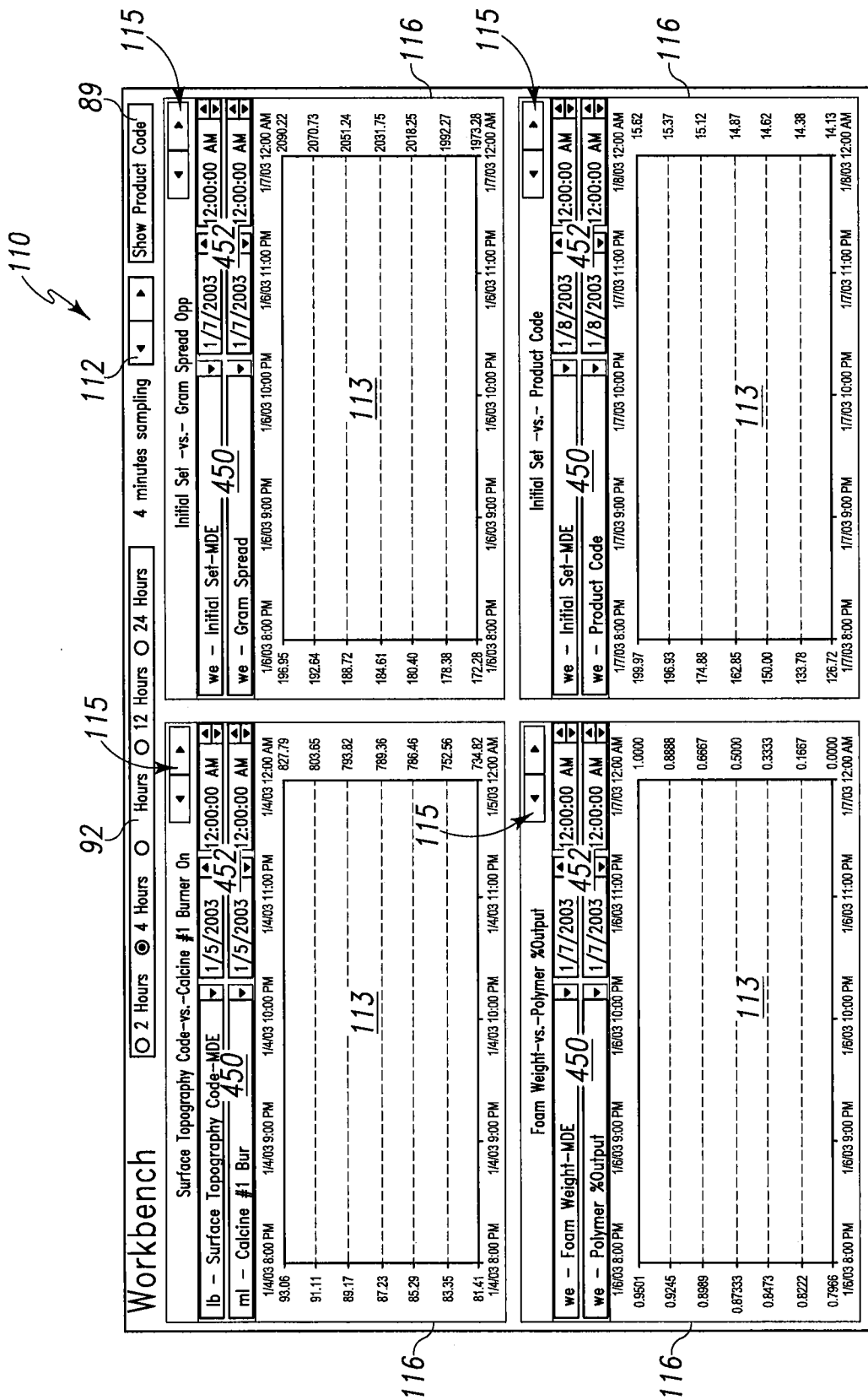


Fig. 8

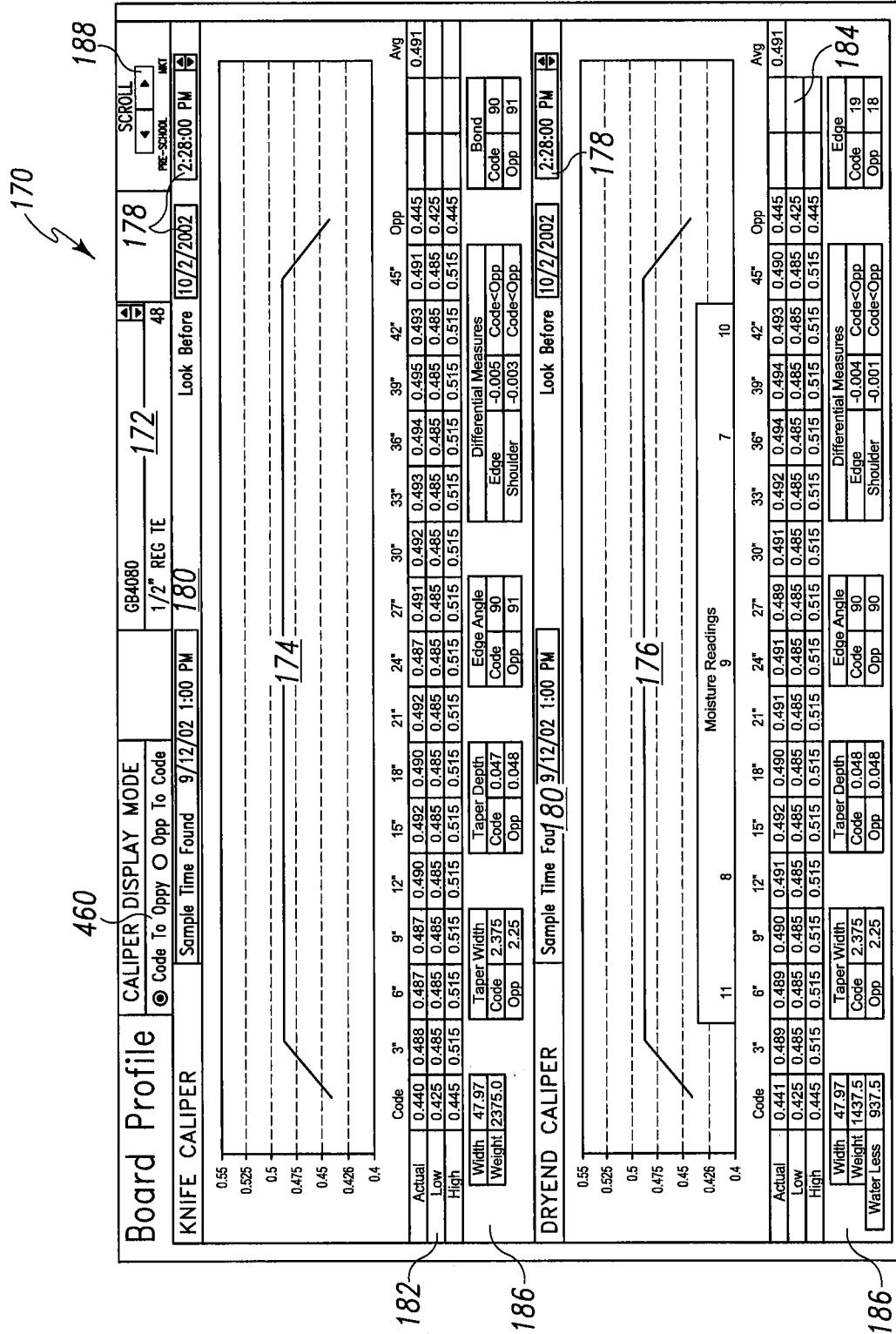
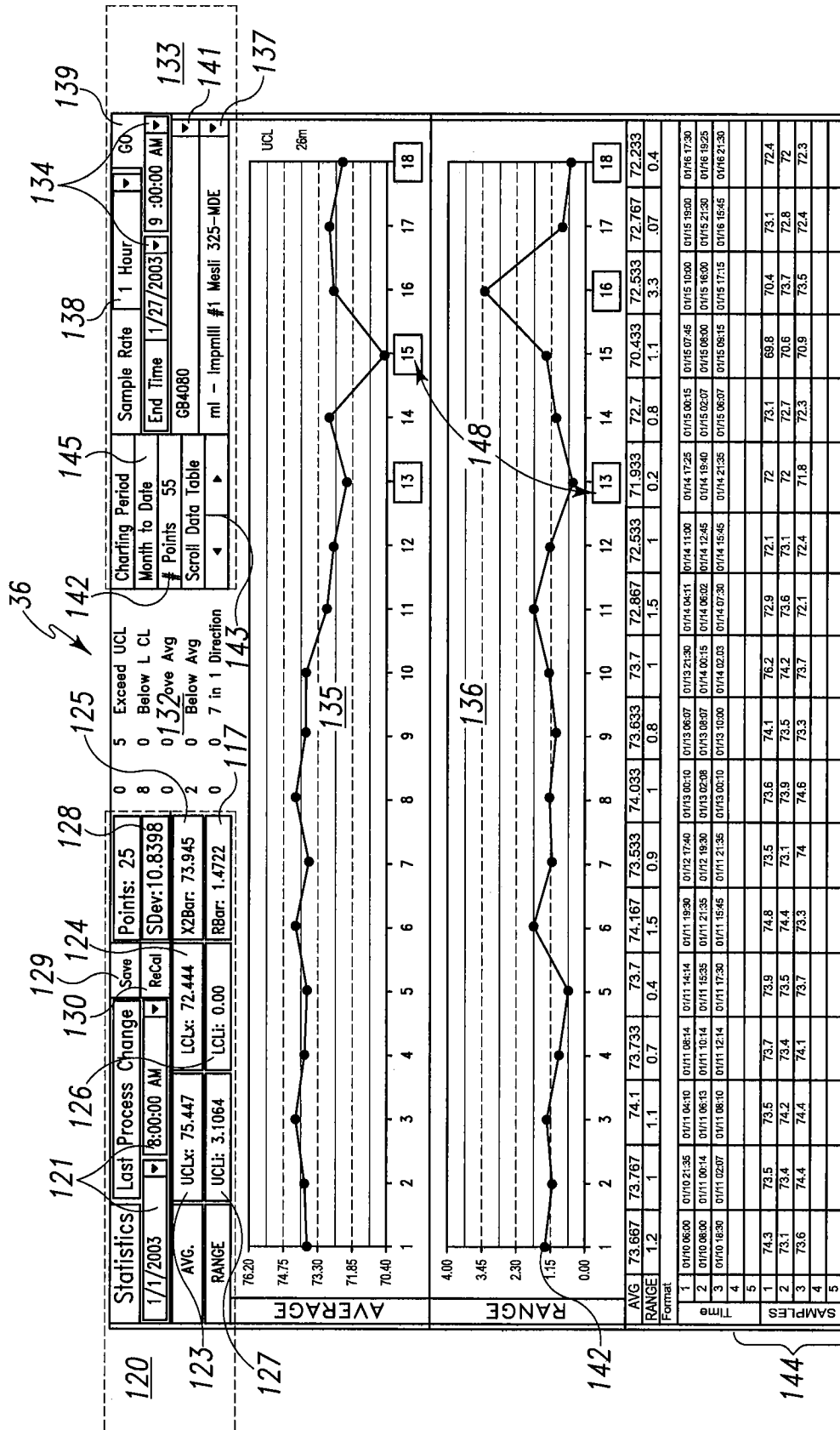


Fig. 9



150

152

SPC Reasons and Actions

ml - Impmill #1 Mesh 325-MDE

154

156

158

160

162

168

169

164

167

Cancel

Best Practices Guide

Save

Timestamp	Value	Reason Code	Description	Corrective Active Code	Description	Previous Reasons/Actions
1/7/03 9:11 AM	73.6					NONE
1/7/03 10:30 AM	73.7					NONE
1/7/03 12:30 AM	69.9					NONE
You can type over the description for codes ending with -9999.		-None- ML-0000 ML-0011 ML-9912 ML-9999	Data entry error. 325 Mesh too fine 325 mesh too coarse Other (You can type text over me)			NONE
						NONE

Use the dropdowns to select the Reason/Action Code from the valid list of codes.

Fig. 11A

150

SPC Reasons and Actions

152 ml - Impmill #1 Mesh 325-MDE

154 TimeStamp

156 Reason Code

158 Description

160 Corrective Active Code

162 Description

168 Previous Reasons/Actions

TimeStamp	Value	Reason Code	Description	Corrective Active Code	Description	Previous Reasons/Actions
1/14/03 5:25 PM	72					NONE
1/14/03 7:40 PM	72					NONE
1/14/03 9:35 PM	71.8					NONE
						NONE
						NONE

Previous Reasons

Previous Actions

475

Close

Cancel

Best Practices Guide

Save

Fig. 11B

The goal of this SOP is to produce stucco that is calcined below theoretical with as few adjustments as possible.

BEST PRACTICE/S.O.P.

166

---

1. Combined water of stucco exceeds the upper limit.

Make sure the grinds are in the reasonable limits.

(Course grounds will cause the moistures to go up)

Examine the history of previous moisture's.

(2 samples in a row high or most of the samples were high)

Examine the purity.

(If the purity went up quite a bit, the moisture's will get higher)

If the grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the upper limits then an adjustment to the calcidyne needs to be made.

When the purity goes up, it may take some time for the calcidyne's to adjust, no need to make adjustments right away. Run a couple of samples and see if they will adjust by themselves. If not make an adjustment.

2. Combined water of stucco is less than the lower limit.

Make sure the grinds are in the reasonable limits.

(Fine grinds will cause the moistures to go down)

Examine the history of previous moisture's.

(2 samples in a row low or most of the samples were low)

Examine the purity.

(If the purity went down quite a bit, the moisture's will get lower.)

If the grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the lower limits then an adjustment to the calcidyne needs to be made.

**Fig. 12**

192 ↗

## Quality Report Login Screen

194  
Open File

189  
Enter Password:  

Required to Change Plant/Server

Enter Password

Required to Activate the Open File Button, if a Corporate User.

195  
Select Plant:  
Apollo Beach

197  
Select Server:  

Select Plant Only if you are at the plant.

Corporate  

Select Corporate only if you are located in Charlotte, or you need to access a plant server other than your own.

199  
The Selected Server Is  
HQADC

Fig. 13



193 →

# MONTHLY BOARD QUALITY REPORT

Select Plant and Date for Report 195

Selected Plants:  196

Select Month & Year:   196

Start Date:  196

End Date:  196

198 →

198

Data must be retrieved before you view Product Details or Reports

206 →

206

Review and Update product information

187 →

Select Products To Include In This Report

Product 1:  210

Product 2:  210

Product 3:  210

Product 4:  210

Product 5:  210

View Product Detail

Product 1 Detail

Product 2 Detail

Product 3 Detail

Product 4 Detail

Product 5 Detail

213 →

View/Print Reports

Monthly Board Report

Monthly Board Weight Report 215

Monthly Mill Report

Server In Use: 199 HQADC

Selected Server: 197 Corporate

Fig. 14

REPLACEMENT SHEET 18  
SERIAL NO.: 10/828,751  
TITLE: SYSTEM AND METHOD FOR PLANT MANAGEMENT  
INVENTORS: PRICE, et al.

MONTHLY BOARD QUALITY REPORT

PRODUCT CODE AND DESCRIPTION	GB4080	GB9950	GB2280	GB0019	GB0116
	1/2" REG TE	5/8" FS TE	1/2" KK TE	1/2" HS TE	1/2" SS HS (Sta-Smooth)
Lab	NAIL PULL - lbs of force				
Number of samples	75	22	1	9	4
Specification (Min)	80.0	90.0	80.0	80.0	80.0
3-Month Rolling Average	71.4	84.8	82.1	70.6	70.9
Standard Deviation	2.722	4.458		2.985	3.081
Year-to-Date Average	71.4	84.8	82.1	70.6	70.9
Prior Year Average	74.886	89.838	85.750	77.067	76.100
Cpk	-1.049	-0.391		-1.046	-0.990
Est. Defects per 1,000 Units	>500	500		>500	>500
Cp	-1.049	-0.391		-1.046	-0.990
Lab	CORE HARDNESS - lbs of force				
Number of samples	68	21	1	9	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	17.1	23.0	19.3	17.1	16.3
Standard Deviation	1.366	1.750		1.054	0.831
Year-to-Date Average	17.1	23.0	19.3	17.1	16.3
Prior Year Average	18.276	23.056	17.333	18.389	16.889
Cpk	0.518	1.514		0.668	0.535
Est. Defects per 1,000 Units	80	<1		40	80
Cp	0.518	1.514		0.668	0.535
Lab	EDGE HARDNESS - CODE - lbs of force				
Number of samples	67	21	1	8	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	56.1	72.4	64.3	56.5	51.7
Standard Deviation	4.725	9.285		6.644	7.193
Year-to-Date Average	56.1	72.4	64.3	56.5	51.7
Prior Year Average	42.430	64.194	55.000	43.845	47.000
Cpk	2.900	2.061		2.080	1.703
Est. Defects per 1,000 Units	<1	<1		<1	<1
Cp	2.900	2.061		2.080	1.703
Lab	EDGE HARDNESS - OPP CODE - lbs of force				
Number of samples	66	21	1	8	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	62.1	75.0	79.3	57.7	62.7
Standard Deviation	5.351	7.700		4.366	0.837
Year-to-Date Average	62.1	75.0	79.3	57.7	62.7
Prior Year Average	49.159	60.030	62.222	46.282	47.000
Cpk	2.934	2.599		3.261	19.016
Est. Defects per 1,000 Units	<1	<1		<1	<1
Cp	2.934	2.599		3.261	19.016
Lab	END HARDNESS - lbs of force				
Number of samples	69	21	1	9	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	16.1	22.2	20.3	16.4	15.2
Standard Deviation	1.385	1.798		0.961	0.638
Year-to-Date Average	16.1	22.2	20.3	16.4	15.2
Prior Year Average	17.829	22.528	18.000	18.028	16.889
Cpk	0.255	1.336		0.488	0.087
Est. Defects per 1,000 Units	300	<1		120	>500
Cp	0.255	1.336		0.488	0.087

Fig. 15

214

Monthly Board Weight Report

PLANT: Wilmington

MONTH: February 2003

431 Return

430 Save As File

1/2" SHEATHING Board	MONTHLY WEIGHT DATA		
	AVG WEIGHT	STD DEV	# OF SAMPLES
December 2002	1719	9	2
January 2003	1713	16	6
February 2003			
March 2003			
April 2003			
May 2003			
June 2003			
July 2003			
August 2003			
September 2003			
October 2003			
November 2003			
December 2003			
YTD AVERAGE	1713	16	6

Fig. 16

208

Product Data										Return
PLC Value	406 Description	Product Code	Width	STD Speed	STD Dry Weight	STD Water Loss	STD-20-Hr Humidified Bond	STD-20-Hr Humidified Bond	Go Live Date	
0	NO PRODUCT RUNNING	NONE	NA	NA	NA	NA	NA	NA	6/1/02 12:00 AM	
1	3/8" TE	GB3990	48"							
2	1/2" TE	GB8000	48"							
3	1/2" KK	GB5620	48"							
4	1/2" FSG	GB6793	48"							
5	1/2" MR	GB3760	48"							
6	1/2" KK FS	GB1242	48"							
7	1/2" HS CEILING	GB0019	48"							
8	1/2" SS (STA SMOOTH)	GB6270	48"							
9	1/2" SHEATHING	GB8000	48"							
10	5/8" FS	GB9950	48"							
11	5/8" MR FS	GB1400	48"							
12	5/8" KK FS	GB1050	48"							
13	5/8" FS JS	GB9466	48"							
14										
15										
16										
17										
18										
19										
20										
21										
22										
23										

Fig. 17

REPLACEMENT SHEET 21  
 SERIAL NO.: 10/828,751  
 TITLE: SYSTEM AND METHOD FOR PLANT MANAGEMENT  
 INVENTORS: PRICE, et al.

31

44

1/2" TE	GB4080	February 2003																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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Fig. 18A

REPLACEMENT SHEET 22  
 SERIAL NO.: 10/828,751  
 TITLE: SYSTEM AND METHOD FOR PLANT MANAGEMENT  
 INVENTORS: PRICE, et al.

	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Taper Depth		Caliper	Nail Pull	Core Hardness	Edge Hardness		End Hardness	d Deflectio	Face Up MO	Face Down	F
February 2003						Code	Opp Code				Code	Opp Code					
3-Month Rolling Avg																	
Average	180.6	420	2511	800	47.997	0.057	0.056	0.490	77.5	21.8	28.8		19.0	0.128	48	50	
Number of Samples	2931		845	54	593	587	588	593	49	3	3	0	3	28	49	49	
LSL					47.29/32	0.050	0.050	0.485	80	15.0	15.0	15.0	15.0		40	40	
USL					48	0.090	0.090	0.515						1.250			
Std Dev	3.464	55.983	45.958	33.603	0.016	0.020	0.017	0.004	4.387	1.072	1.411		0.882	0.025	4.442	3.550	
Std Dev / 1.7321	2.000	31.967	26.533	19.400	0.009	0.011	0.010	0.002	2.533	0.619	1.392		0.509	0.014	1.584	2.050	
Cpk					0.115	0.948	1.176	3.890						26.366			
Cpk					3.230	0.217	0.222	0.829	-0.334	3.652	3.299		2.619		1.037	1.866	
Cpk					0.115	0.217	0.222	0.829	-0.334	3.652	3.299		2.619	26.366	1.037	1.866	
Cp					1.673	0.583	0.699	2.359	-0.334	3.652	3.299		2.619	26.366	1.037	1.866	
3-Month Period Ending	181.1	1712	2509	796	48.00	0.058	0.056	0.490	77.5	21.8	28.8		19.0	0.128	48	50	
January	180.6	421	2511	800	4800	0.057	0.056	0.490	77.5	21.8	28.8		19.0	1.128	48	50	
February	179.9		2517	807	48.00	0.056	0.057	0.491	77.5	21.2	30.2		19.2	1.117	51	51	
March	177.0		2527	835	48.00	0.053	0.057	0.492									
April																	
May																	
June																	
July																	
August																	
September																	
October																	
November																	
December																	

Fig. 18B

	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Taper Depth		Caliper	Nail Pull	Core Hardness	Edge Hardness		End Hardness	d Deflectio	Face Up MO	Face Down	F
Current Year Info						Code	Opp Code				Code	Opp Code					
Year-to-date Avg	179.9	422	2517	807	48.00	0.056	0.057	0.491	77.1	21.2	30.2		19.2	0.117	51	51	
Entire Year Avg	179.9		2517	807	48.00	0.056	0.057	0.491	77.1	21.2	30.2		19.2	0.117	51	51	
December (Last Year)	181.5	1411	2502	791	48.00	0.060	0.056	0.490	77.8	23.0	26.0		18.7	0.133	45	49	
January	180.7	1714	2515	801	48.00	0.056	0.056	0.490	77.1	21.2	30.2		19.2	0.117	51	51	
February	177.0	1682	2527	835	48.00	0.053	0.057	0.492									
423																	
Prior Year Info																	
Overwrite I-Historian Data																	
Enter Year Avg																	
I-Historian Data	176.1	422	2502	791	48.00	0.060	0.056	0.490	77.8	23.0	26.0		18.7	0.133	45	49	
Year-to-date Avg																	
Entire Year Avg	176.1	1714	2502	791	48.00	0.060	0.056	0.490	77.8	23.0	26.0		18.7	0.133	45	49	

424

Fig. 18C

250





255

APOLLO	▼
Baltimore 1	
Baltimore 2	
Burlington	
Fort Dodge	
Long Beach	
Lorain	
Medicine Lodge 1	
Medicine lodge 2	
National City	
Phoenix	
Portsmouth	
Rensselaer	
Richmond	
Rotan	
Savannah	
Shippingport	
Shoals	
Tampa 1	
Tampa 2	
Waukegan	
Westwego	
Wilmington	

Fig. 20B

Select Period / Frequency

256

Select Period/Frequency:

1 Day - Every 15 Minutes

1 Day - Every 15 Minutes

1 Day - Every 30 Minutes

1 Day - Every Hour

1 Day - Every 2 Hours

1 Week - Every 2 Hours

1 Week - Every 4 Hours

1 Week - Every 8 Hours

1 Week - Every 12 Hours

1 Month - Every 8 Hours

1 Month - Every 12 Hours

1 Month - Every Day

Fig. 20C

Select Server

257

Select Server

Corporate Server

Corporate Server

Plant Server

If you are at a plant, you should select Plant Server.  
 Likewise, if you are in Charlotte, you should select  
 Corporate Server.

Fig. 20D

Select Measures (Tags)

258

WE	KF	DE	KF	DE	KF	DE	KF
WE	Product Code						
WE	Product Code Test						
WE	Pulp %Output						
WE	Pulp Actual						
WE	Pulp Feed Tank Level Gals						
WE	Pulp Target						
WE	Pulper Batch Actual						
WE	Pulper Batch Potash Actual						
WE	Pulper Batch Potash Target						
WE	Pulper Batch Starch Actual						
WE	Pulper Batch Starch Target						
WE	Pulper Batch Target						
WE	Pulper Batch Time Remaining						
WE	Pulper Batch Time Target						
WE	Pulper Batch Waste Water Actual						

Caliper  
Average

Fig. 20E

**Dry End Manual Data Entry**

Plant Line  
SHO 1

Set Up

Product Code  
GB4080

Select Product Code  
10/1/2002

Width  
48"

Description  
1/2" REG TE

Select Code Time  
10:00

Minimize

SPC Chart

Board Profile

View Dry End Data

Accept

Dry Width  
Inches

Dry Scale Weight  
Lbs

Dry Weight  
Inches

Code Edge  
3" 6" 9" 12" 15" 18" 21" 24" 27" 30" 33" 36" 39" 42" 45" 48" 51" Opp Edge

Edge Differential  
Thousands of an inch

Code Taper Depth  
Thousands of an inch

Code Taper Width  
Inches

Code Edge Angle  
Degrees

Code Edge Hardness  
Avg Lbs Force

Average Field Caliper  
48"

Shoulder Differential  
Thousands of an inch

Opposite Taper Depth  
Thousands of an inch

Opposition Taper Width  
Inches

Opposition Edge Angle  
Degrees

Opposite Edge Hardness  
Avg Lbs Force

Moisture Profile

Kiln Drive Side  
Code 6" 12" 24" 36" 48" 60" 72" 84" 96" 108" 120" 132" 144" 156" 168" 180" 192" 204" 216" 228" 240" 252" 264" 276" 288" 300" 312" 324" 336" 348" 360" 372" 384" 396" 408" 420" 432" 444" 456" 468" 480" 492" 504" 516" 528" 540" 552" 564" 576" 588" 600" 612" 624" 636" 648" 660" 672" 684" 696" 708" 720" 732" 744" 756" 768" 780" 792" 804" 816" 828" 840" 852" 864" 876" 888" 900" 912" 924" 936" 948" 960" 972" 984" 996" 1000"

Opp Drive Side  
Code 6" 12" 24" 36" 48" 60" 72" 84" 96" 108" 120" 132" 144" 156" 168" 180" 192" 204" 216" 228" 240" 252" 264" 276" 288" 300" 312" 324" 336" 348" 360" 372" 384" 396" 408" 420" 432" 444" 456" 468" 480" 492" 504" 516" 528" 540" 552" 564" 576" 588" 600" 612" 624" 636" 648" 660" 672" 684" 696" 708" 720" 732" 744" 756" 768" 780" 792" 804" 816" 828" 840" 852" 864" 876" 888" 900" 912" 924" 936" 948" 960" 972" 984" 996" 1000"

End Peel

Kiln Drive Side  
Face Back

Opp Drive Side  
Face Back

Surface Appearance  
Code Center Opp

Fig. 21

**Fig. 22**

**301** → **305** **Mill Manual Data Entry**

**306** Minimize **307** SPC Chart **310** View Mill Data **Accept**

**308** Set Up

Select Date Time: **10/1/2002** **311** **10:00:00 AM** **SHO** Plant: **SHO** **Calcination** ☒

Rock FGD	Purity <input checked="" type="checkbox"/> %	Free Water <input checked="" type="checkbox"/> %	Calcination <input checked="" type="checkbox"/>
Raymond Mill #1	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	100 Mesh <input checked="" type="checkbox"/> %
Raymond Mill #3	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	100 Mesh <input checked="" type="checkbox"/> %
Raymond Mill #5	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	100 Mesh <input checked="" type="checkbox"/> %
Raymond Mill #7	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	100 Mesh <input checked="" type="checkbox"/> %

Composite Land Plaster	Retry Comb H <sub>2</sub> O <input checked="" type="checkbox"/> %	Retry Purity <input checked="" type="checkbox"/> %	Rock % Cal-cination <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %
Calcydine #1	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %	Calcydine #1 <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %
Calcydine #3	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %	Calcydine #3 <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %
Calcydine #5	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %	Calcydine #5 <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %

Composite Calcined Stucco	Combined Water Gilmore 1/4# Set <input checked="" type="checkbox"/> %	Consistency Gilmore 1# Final Set <input checked="" type="checkbox"/> %	ml/100 grams <input checked="" type="checkbox"/> %
Imp Mill #1	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %
Imp Mill #3	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %

Composite Imp Mill Stucco	Combined Water Gilmore 1/4# Set <input checked="" type="checkbox"/> %	Consistency Gilmore 1# Final Set <input checked="" type="checkbox"/> %	ml/100 grams <input checked="" type="checkbox"/> %
Imp Mill #1	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %
Imp Mill #3	100 Mesh <input checked="" type="checkbox"/> %	325 Mesh <input checked="" type="checkbox"/> %	Combined H <sub>2</sub> O <input checked="" type="checkbox"/> %

**315**

302

305

306

314

307

310

308

315

Wet End Manual Data Entry 312

Select Product: GB4080 313

Product Code GB4080 Desc 1/2" REG TE 48" 311

Select Date & Time 10/1/2002 10:00:00 AM

Print Page

Set Up

Plant SHO Line 1

Cylinder Weight Code	X	grams	Gram Spread Code	X	grams
Cylinder Weight Field	X	grams	Gram Spread Opp	X	grams
Cylinder Weight Opp	X	grams			

Initial Set (TTU)	X	mm/ss	Field Set	X	mm/ss
Gilmore (TTU) Set	X	mm/ss	Gilmore 1# Final Set	X	mm/ss
Slump	X	Inches			

Boot Temperature	X	%	Differential Boot-Head	X	"
Head Temperature	X	%			

Stucco Combined Water	X	%	Stucco Consistency	X	ml 100 grams
Foam Weight	X	mm/ss	H2O/Stucco Ratio	X	

Minimize

SPC Chart

Board Profile

View Wet End Data

Accept

Fig. 23

Fig. 24

304 →

312

### LAB MANUAL DATA ENTRY

Plant  Line  Select Product:

Product Code  Width  Description

Select Date  Select Time

306

314

307

308

Dry/ Weight		Weight <input type="text" value=""/>		Lbs		<input type="button" value="Accept"/>	
Transverse Strength	Face Up/MD	<input type="text" value=""/>	Lbs	Face Down MD	<input type="text" value=""/>	Lbs	<input type="button" value="Accept"/>
	Face Up XMD	<input type="text" value=""/>	Lbs	Face Down XMD	<input type="text" value=""/>	Lbs	
Nail Pull	Test 1	<input type="text" value=""/>	Lbs	Test 2	<input type="text" value=""/>	Lbs	<input type="button" value="Accept"/>
	Test 1	<input type="text" value=""/>	Lbs	Test 3	<input type="text" value=""/>	Lbs	
Core Hardness	Test 1	<input type="text" value=""/>	Lbs	Test 2	<input type="text" value=""/>	Lbs	<input type="button" value="Accept"/>
	Test 1	<input type="text" value=""/>	Lbs	Test 3	<input type="text" value=""/>	Lbs	
End Hardness	Test 1	<input type="text" value=""/>	Lbs	Test 2	<input type="text" value=""/>	Lbs	<input type="button" value="Accept"/>
	Test 1	<input type="text" value=""/>	Lbs	Test 3	<input type="text" value=""/>	Lbs	
Code Edge Hardness	Test 1	<input type="text" value=""/>	Lbs	Test 2	<input type="text" value=""/>	Lbs	<input type="button" value="Accept"/>
	Test 1	<input type="text" value=""/>	Lbs	Test 3	<input type="text" value=""/>	Lbs	
Opposite Edge Hardness	Test 1	<input type="text" value=""/>	Lbs	Test 2	<input type="text" value=""/>	Lbs	<input type="button" value="Accept"/>
	Test 1	<input type="text" value=""/>	Lbs	Test 3	<input type="text" value=""/>	Lbs	

310

315

Fig. 25